* ID 53308 3:18:54 PM B67-43001-59				-				P	Page 1
B67-43001-59		Accept				s	etup Star Sto		
0/30/2009. Start Qty: 1.00 1/13/2009 Req'd Qty: 1.00	UNI 10 U		Cust Item I Customer:	D:	•.				
Process Plan: MF					-	F			
Operation Description		Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Insp Number Star	
Revision Nbr									
Rev B1					ļ				
Large Fab Memo		0.00			8	2 10	-01	08',	
105 to -1: .113 as pe	3 as per dwg and grind weld dwg PB67-43001 □4- pick t	flush □ 3- weld 119, -11	7 and -115 to -					,	
QC9- Inspect visual p	er QSI004- Fusion Welds	0.00				BD 16	0.01.08		
1 F	Process Plan: Pr	Process Plan: MF Date: 09-10-2 QC: Date: Operation Description Revision Nbr Rev B1 Large Fab Memo 1- to make -105 take M6061T6 tube an 105 to -113 as per dwg and grind weld 113 as per dwg PB67-43001 14- pick to tubing but only one need to b QC9- Inspect visual per QSI004- Fusion Welds	Process Plan:	Process Plan: Process Plan: Date: Operation Description Revision Nbr Rev B1 One on the company of the contour of th	Customer: Process Plan: WF Date: O9-10-29 Tooling: Date: Operation Set Up/ Draw Draw Description Run Hours Number Rev.	Process Plan: Date: O9-10-29 Tooling: Date: Operation Description Rev B1 Date: SPC (Y/N): Draw Plan Number Rev. Code Revision Nbr Rev B1 O.00 Large Fab Memo O.00 1- to make -105 take M6061T6 tube and fabricate to fit contour of cut□2- Weld -105 to -113 as per dwg and grind weld flush□3- weld 119, -117 and -115 to -113 as per dwg PB67-43001□4- pick two -271 and weld one on each side of tubing but only one need to b QC9- Inspect visual per QS1004- Fusion Welds O.00	Customer: Process Plan: WF Date: 09-10-29 Tooling: Date: Date: Date: Date: Date: Date: Date: Date: Date: Date: Date: Date: Date: Date: Date:	Customer: Process Plan: MF	Customer: Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Start Run Run

120 QC

QC5- Inspect part completeness to step on W/O

Quality Control

Memo

Dart Aerospace Ltd

W/O:			WO	RK ORDER CHANG	ES			, 10.	
DATE	STEP	PRO	OCEDURE CHAI	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No	:	PAR #:	Fault Categ	jory:	_ NCR: Yes	No DQ	A :	Date:	· · ·
	R	esolution:	Disposition	:	_ QA: N/C Clo	osed:		Date: _	
NCR:		•	WORK ORDE	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC		Corrective Action Secti		Verific		Approval	Approval
		Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section	on C	Chief Eng	QC Inspector

B1

Page 2

October 29, 2009 3:18:54 PM

Item ID:

PB67-43001-59

Accept

Setup Start



Revision ID:

Start Date:

PB67-43001-59 Item Name:

Required Date: 11/13/2009

10/30/2009

Start Qty: 1.00

Req'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date: **Tooling:**

SPC (Y/N):

Date:

Date:

Draw

Rev.

Run

Accept

Qty

Start

Stop



Sequence ID/ **Work Center ID**

130

HandFinish

Hand Finishing

Operation Description

Chemical Conversion Coat per OSI005 4.1

Date:

Memo

Set Up/ **Run Hours**

Plan

Code

Stop

Reject

Qty

Reject

Insp. Number Stamp

140

Powdercoat

Powder Coating

Green Sandtex(Ref:4.3.5.8) per QSI005 4.3

START TIME:

0.00

0.00

Bl 10-01-11 0

OOVEN TEMPERATURE:

150

QC3-Inspect Part Finish

0.00

10-01-11

Quality Control

Memo

0.00

Dart Aerospa	ce	Ltd
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W/O:			W	ORK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	NGE	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: Yes	No DQ	A:	Date:	
		solution:							
NCR:		,	WORK ORD	ER NON-CONFORMA	ANCE (NCF	l)			177
DATE	STEP	Description of NC		Corrective Action Section		Verific	ation	Approval	Approval
	0121	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Secti	on C	Chief Eng	QC Inspector
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Page 3

Item ID:

PB67-43001-59 Accept

Setup Start

Stop



Revision ID: B1

Item Name: PB67-43001-59

Required Date: 11/13/2009

Start Date:

10/30/2009

Start Qty: 1.00

Reg'd Qty: 1.00



Cust Item ID:

Customer:

Draw

Number

Reference:

Approvals:

Process Plan:

Date:

Tooling:

0.00

0.00

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/

Work Center ID

160

Small Fab

Small Fab

Operation Description

Small Fab

Set Up/

Run Hours

Draw Rev.

Date:

Plan Code

Accept Reject Qty Qty

Reject Number Stamp

Insp.

Memo

_____ Date:

1- take -267 and transfer drill holes in -113 as per dwg PB67-43001 \(\prec22 \) deburr and rivet -267 to -113 as per dwg□3- assemble rest of parts as per dwg PB67-

43001

Memo

SAP 10-01-12

170

Quality Control

QC5- Inspect part completeness to step on W/O

Identify as per dwg & Stock Location: (137)

180

Packaging

Memo

0.00

0.00

16-1-12



Packaging

-a	Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	ES					
DATE	STEP	PRO	OCEDURE CHAI	IGE	Ву		Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part NO	·	PAR #:	Fault Categ	jory:	_ NCH: Y	es N	o DQ/	4:	_ Date: _	
	n n	esolution:					ed:		Date:	
NCR:				ER NON-CONFORMA	ANCE (N	CH)				
DATE	STEP	Description of NC	Initial	Corrective Action Section		ın &	Verific		Approval	Approval
		Section A	Chief Eng	Action Description Chief Eng		ate	Secti	on C	Chief Eng	QC Inspector
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Work Order ID 53308

Page 4

October 29, 2009 3:18:54 PM

Item ID:

PB67-43001-59

B1

Revision ID: PB67-43001-59

Item Name:

Start Date:

10/30/2009

Start Qty: 1.00

Req'd Qty: 1.00

Accept



Setup Start

Stop



Required Date: 11/13/2009

Reference:

Approvals:

Process Plan:

QC:

Operation

Description

Date:

Date: Tooling:

SPC (Y/N):

Set Up/

Number

Draw

Cust Item ID:

Customer:

Date:

Draw

Rev.

Plan

Code

Date:

Run

Start



Stop

Sequence ID/ **Work Center ID**

190

Memo

QC21- Final Inspection - Work Order Release

0.00

Run Hours

0.00

Accept Qty

Reject Qty

Reject Number

Insp. Stamp

Quality Control

10/01/13 de) MC Ph ->

Dail Acidsbace Liu	Dart	Aeros	pace	Ltd
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W/O:			W	ORK ORDER CHANG	ES					
DATE	STEP	PRO	CEDURE CH	NGE	В	у	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Part No		PAR #:								
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NCR:			WORK ORD	ER NON-CONFORMA	NCE (N	ICR)				
DATE	STEP	Description of NC		Corrective Action Secti			Verific	cation	Approval	Approval
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Picklist Print												Page 1
October 29, 2009 3	::18:54 PM											
Work Order ID: 53	3308								· · · · · · · · · · · · · · · · · · ·			. 5
Parent Item: PE	B67-43001-59RevB1											•
Parent Item Name:	PB67-43001-59		1 5 3 4 6 1	1881 (181 IB) 8 B illi (68)	310831 DIDDE 11111 86111 70 :		FILE 1918 III \$118191 IBB		tart Date: 10/30	0/2009	Required Date:	11/13/2009
Comments:						1			Start Qty: 1.00		Required Qty:	
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seg ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
30345T21		Purchased	No			160	Each	41.0000	2.0000	ેં	209.10	2.15
				Wareho	<u>use</u>	Loc	<u>Oty</u>	Loc Code				
				Loca	<u>ıtion</u>				ı			
				Main Wa	arehouse							
				ST			41				-	
BSP43		Donatoral	No		17828	160	41 	114 0000	<u> </u>	_ 3 x	-	
RIVET	l	Purchased	NO			160	Each	114.0000	6.0000	Sy	009.1J	15
				<u>Wareho</u> <u>Loc</u> s	use ation	<u>Loc</u>	Oty	Loc Code				Phi
				Main Wa	arehouse							
				ST			114		_		-	
					109119		20				-	
					110704 111127		50 44			OX	-	
M6061T6T1.750W.065		Purchased	No			160	.f	44.5800	0.1579		-	
6061T6 RDTUBE 1.750										Sp /	O. 01	07.
				<u>Wareho</u> <u>Loc</u> :	use ation	Loc	<u>Oty</u>	Loc Code				
				Main Wa								
	•			MA			44.58				_	
					108551		2.24		_			
					109397 110885		0.4 1 6.69				-	
					111432		25.25		į –		- -	

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W/0:5	3308	WORK ORDER CHANGES	3		· · · · ·		
DATE	STEP	PROCEDURE CHANGE .	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
(0.01.12	160	Add to Parts list AN960 JD4L B14606 (1 PER RIVET) TOTAL = 4. DERMAJENT CHG	1	60/01/13		10.01.12	Solocha
				101/19			

Part No: <u>PB67-4300 -59</u> PAR #:	Fault Category:	NCR: Yes No DQA:	Date:
Resolution:	Disposition:	QA: N/C Closed:	Date:

NCR:			WORK ORDE	ER NON-CONFORMANO	CE (NCR)			
		Description of NC		Corrective Action Section B		Verification	Annroyal	Annroval
DATE	STEP	Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Section C	Approval Chief Eng	Approval QC Inspector
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October 29, 2009 3:18:54 PM

Work Order ID: 53308

PB67-43001-59RevB1

Parent Item Name:

PB67-43001-59

Comments:

Parent Item:



Start Date: 10/30/2009

Required Date: 11/13/2009

Start Qty: 1.00

Required Qty: 1.00

	Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
1	MS17984-C413	23	Purchased	No			160	Each	12.0000	2.0000			



PIN, QUICK RELEASE

Warehouse	Loc Oty	Loc Code	•
Location			
Main Warehouse			
ST	12		
109031	4		
111060	8		

Each

MS21042L3

Purchased

No

160

3,322.000 2.0000

5009.12.15

Sp 09.12.15

Warehouse	Loc Qty	Loc Code	
Location			
Main Warehouse			
ST	3322		
110844	32		
111274	29		
111668	761		
112314	2000		2x
112385	500		

	Dart	Aeros	pace	Ltd
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W/O:			WO	RK ORDER CHANG	BES					
DATE	STEP	PR		Зу	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector		
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75.49										
Part No		PAR #:								
	Res	solution:	Disposition):	QA: N	I/C Clo	sed:		Date: _	
NCR:			WORK ORDE	ER NON-CONFORM	ANCE (NCR)			
DATE	STEP	Description of NC Section A	Initial Chief Eng	Corrective Action Section Description Chief Eng		Sign & Date		cation on C	Approval Chief Eng	Approval QC Inspector
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October 29, 2009 3:18:54 PM

Work Order ID: 53308

PB67-43001-59RevB1

Parent Item Name:

PB67-43001-59

Purchased

No

Comments:

NAS1149F0332P

Parent Item:



Start Date: 10/30/2009

Required Date: 11/13/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS27039-1-22		Purchased	No			160	Each	126.0000	2.0000			
					γ_{ℓ}	118057				SAD	10-01-6	}

SCREW

Warehouse Loc Oty Location Main Warehouse ST 126 112940 100 18057 26 100

Loc Code Each 1,144.000 4.0000

0 09 1210

WASHER			1 18811 1881	5001.12.15
	Warehouse	Loc Oty Loc Code		
	Location		:	
	Main Warehouse			•
	ST	1144	•	
	18057	1144		<u>4x.</u>
PB67-43001-113RevB1 Manufacture	d No	100 Each 0.0000	1.0000	
K		54626 1X		Sp 10.01.07.
PB67-43001-115RevC Manufacture	d No	100 Each 0.0000	1.0000	-
Tube End Plate		24807 11		Sp 09. 12.75
PB67-43001-117RevC Manufacture	d No	100 Each 0.0000	1.0000	•
Hook Plate		41865 IX		SP 09.12.15

Dart	Aero	space	Ltd
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W/O:			WC	RK ORDER CHANG	ES				
DATE	STEP	PRO	OCEDURE CHA	Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector	
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=									
Part No		PAR #:	Fault Cate	gory:	NCR: Yes	No DQ	\ :	Date: _	
	Res	solution:				 	Date: _		
NCR:	-		WORK ORDI	ER NON-CONFORMA	NCE (NCR)			
DATE	STEP	Description of NC	Initial	Corrective Action Section Action Description	on B Sign &	Verific		Approval	Approval
		Section A	Chief Eng	Chief Eng	Date	Section	on C	Chief Eng	QC Inspector
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Work Order ID: 53308

Parent Item:

PB67-43001-59RevB1

Parent Item Name: PB67-43001-59

Comments:



Start Date: 10/30/2009

Required Date: 11/13/2009

Start Oty: 1.00

Required Oty: 1.00

Comments:								2	Start Qty: 1.00		Required Qty: 1.00
Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Status Issued
PB67-43001-119RevC		Manufactured	No			100	Each 41478	0.0000 X	1.0000	&P	09.12.15
PB67-43001-121RevB1		Manufactured	No		•	160	Each	5.0000	1,0000	Sp	09:12,15
				<u>Warehoo</u> <u>Loca</u> Main Wa	tion	<u>Loc</u>	<u>Qty</u>	Loc Code			
PB67-43001-267RevB1		Manufactured	No	ST	43329	160	5 5 Each	9.0000	1.0000	11	·
PB67-43001-267					•					Sp	09.12.15
				Warehor	<u>ition</u>	<u>Loc</u>	<u>Oty</u>	Loc Code			
				Main Wa			9		_		
					41497		1		_	1.1	

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Dart Aerospace Ltd

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W/O:			WC	RK ORDER CHANG	ES					
DATE	STEP	PR	PROCEDURE CHANGE				Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
Part No	:	PAR #:	Fault Cate	gory:	_ NCR: `	Yes N	lo DQ	A:	Date: _	
	Re	esolution:	Disposition	n:	_ QA: N	C Clos	sed:		Date: _	
NCR:			WORK ORDI	ER NON-CONFORM	ANCE (I	NCR)				
DATE	STEP	Description of NC		ion B	: 0	Verification			Approval	
	0.2.	Section A	Initial Chief Eng	Action Description Chief Eng		ign & Date	Secti	on C	Chief Eng	QC Inspector
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Picklist Print

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Work Order ID: 53308

PB67-43001-59RevB1

Parent Item Name:

PB67-43001-59

Comments:

Parent Item:



Start Date: 10/30/2009

Required Date: 11/13/2009

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name

Replacement Mfg/ Item ID

Purch

Primary Bin Item Location Last Location Route Seq ID Unit of Measure

Qty on Hand

Remaining Qty To Pick

Qty Issued Date Status Issued

PB67-43001-271RevB1

Manufactured

No

100

Each

16.0000

2.0000

Sp09.12.15

Doubler

Warehouse

Loc Qty

Loc Code

Location

Main Warehouse

ST

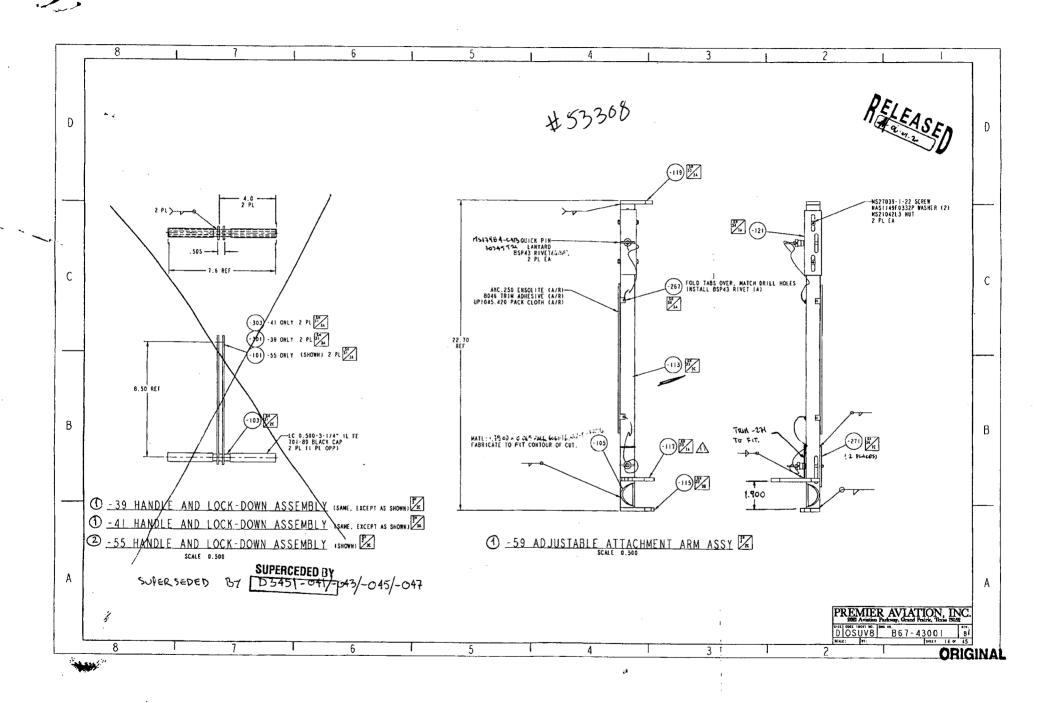
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W/O:			W	ORK ORDER CHANGI	ES				
DATE	STEP	PROCEDURE CHANGE			Ву	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
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Dort No.		DAD #-	FIt O-4		NOD	N- 50		5 -4-	<u>†</u>
Part NO					CR: Yes No DQA: Date:				
	— н	esolution:						Date: _ 	
NCR:			WORK ORL	DER NON-CONFORMA	NCE (NCF	₹)			
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verificatio		Approval	Approval
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W/O:		WORK ORDER CHANGES									
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Part No:		PAR #:	Fault Category: NC			CR: Yes No DQA: Date:					
	R	esolution: Disposition: O				A: N/C Closed: Date: _					
NCR:		\	WORK ORDI	ER NON-CONFORMA	NCE (NCF	R)					
DATE	STEP	Description of NC Section A			on B	Verification	Approval	Approval			
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NOTE: Date & initial all entries

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